

Split
Work Order ID 148015-4

June 17, 2016 1:09:53 PM

Oty 2 needed for Bell.
148015

Rush need for Monday.

Page 1

Item ID: D3709-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Angle
Start Date: 6/17/2016 Start Qty: 10.00 *10* Cust Item ID:
Required Date: 6/20/2016 Req'd Qty: 10.00 *10* Customer:
Reference:

Approvals: Process Plan: SW Date: 6/17/16 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3709	Rev A

100 FLOW WATER JET 0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3709
Dwg Rev: A

Prog Rev: A

****grain direction on a 45 degree ****

2- DEBURR BY HAND ONLY

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Quality Control

Memo

0.02

PR 16/06/17

10

10

PR 2016/06/17

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																														
Date : _____		Step #: _____		QTY Effective : _____			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																																																																											
Description Work Order Deviation				Disposition																																																																																																																														
<table style="width:100%; border-collapse: collapse;"> <tr> <th colspan="4" style="text-align: left; border-bottom: none;">Root Cause</th> <th colspan="5" style="text-align: left; border-bottom: none;">FAULT CATEGORY</th> </tr> <tr> <td style="width:10%; border-right: 1px solid black;">Environment</td> <td style="width:10%;">☐</td> <td style="width:10%; border-right: 1px solid black;">No Re-verification</td> <td style="width:10%;">☐</td> <td style="width:10%; border-right: 1px solid black;">Pressure/Forced</td> <td style="width:10%;">☐</td> <td style="width:10%; border-right: 1px solid black;">Temperature/Cure</td> <td style="width:10%;">☐</td> <td style="width:10%; border-right: 1px solid black;">Power Loss/Surge</td> <td style="width:10%;">☐</td> </tr> <tr> <td style="border-right: 1px solid black;">Design</td> <td>☐</td> <td style="border-right: 1px solid black;">Operator</td> <td>☐</td> <td style="border-right: 1px solid black;">Bending</td> <td>☐</td> <td style="border-right: 1px solid black;">Set-up</td> <td>☐</td> <td style="border-right: 1px solid black;">Folio/Program</td> <td>☐</td> </tr> <tr> <td style="border-right: 1px solid black;">Doc/Data</td> <td>☐</td> <td style="border-right: 1px solid black;">Offset/Setup</td> <td>☐</td> <td style="border-right: 1px solid black;">Centre Not Concentric</td> <td>☐</td> <td style="border-right: 1px solid black;">BOM/Route</td> <td>☐</td> <td style="border-right: 1px solid black;">Grain</td> <td>☐</td> </tr> <tr> <td style="border-right: 1px solid black;">Equip/Tooling</td> <td>☐</td> <td style="border-right: 1px solid black;">Supplier</td> <td>☐</td> <td style="border-right: 1px solid black;">Cracks</td> <td>☐</td> <td style="border-right: 1px solid black;">Broken/Damage/Defect</td> <td>☐</td> <td style="border-right: 1px solid black;">Weld</td> <td>☐</td> </tr> <tr> <td style="border-right: 1px solid black;">Handling/Pre</td> <td>☐</td> <td style="border-right: 1px solid black;">Training</td> <td>☐</td> <td 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Pulled	☐	Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____					Misidentified	☐	Past Due	☐
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Work Order ID 148015

148015

Page 2

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Item ID: D3709-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Angle
 Start Date: 6/17/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 6/20/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.03				(10)			DAS 38 9-89 JUN 20 2016
130 *130* Small Fab Small Fab	Small Fab Memo Form as per dwg D3709	0.00 0.40			DAS 30 9-89	(2)			JUN 20 2016
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.03				(2)			DAS 38 9-89 JUN 22 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition																					
								Completed By																	
								Lead hand / Supervisor Approval Verification																	
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Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
OTHER :																									

Work Order ID 148015

148015

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June 17, 2016 1:09:53 PM

Item ID: D3709-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Angle
 Start Date: 6/17/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 6/20/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.07							
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							
160									
QC	Memo	0.03							
Quality Control									
170	Identify as per dwg & Stock Location: <u>51235</u>	0.00							
170									
Packaging	Memo	0.02							
Packaging									

24 d 16/06/27

(2)

DAS
38
JUN 22 2016

2

JUN 22 2016

DAS
6
JUN 22 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Work Order ID 148015***148015***

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June 17, 2016 1:09:53 PM

Item ID: D3709-1 Accept *N900040100* Setup Start *NS1*
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Item Name: Angle
Start Date: 6/17/2016 Start Qty: 10.00 *10* Cust Item ID:
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Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.17							
Quality Control									

ML5 JUN 23 2016
Em 16/06/23

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
71000 R & B111								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

June 17, 2016 1:09:57 PM

Work Order ID: 148015
 Parent Item: D3709-1
 Parent Item Name: Angle

148015
D3709-1

Start Date: 6/17/2016 Required Date: 6/20/2016
 Start Qty: 10.00 Required Qty: 10.00

Comments: IPP Rev:A 08-10-31 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No			sf	724.9000		2.8			

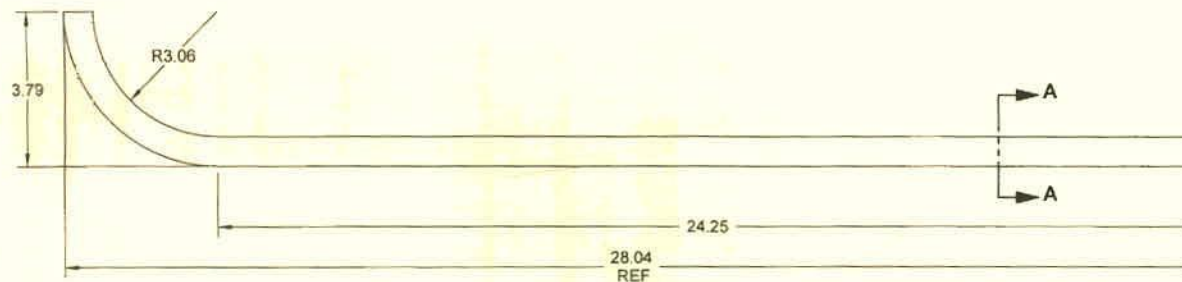
M6061T6S 063
 6061-T6 .063 Sheet

**

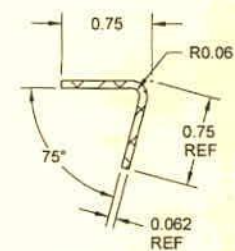
Pl 2016/06/17

Location	Loc Qty	Loc Code
MAT021	388.9	
M133511	2.6	
M134377	3.3	
M134830*	383	
TPI	336	
M134496	192	
M134604	144	

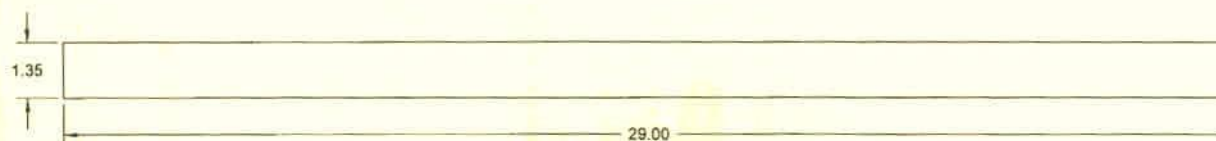
 3.1



D3709-1 ANGLE
(MAKE FROM D3709-1F)



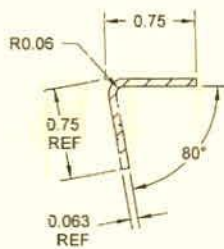
SECTION A-A
SCALE 2X



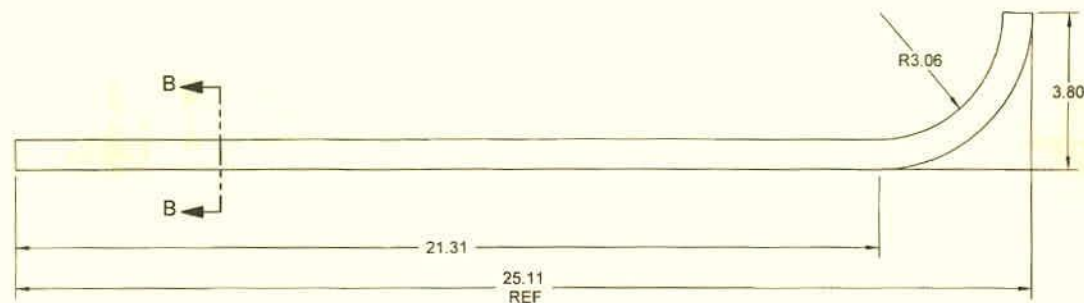
D3709-1F ANGLE FLAT PATTERN

RELEASED
09/04/09

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D3709	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE ANGLE	SCALE NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.05.02		

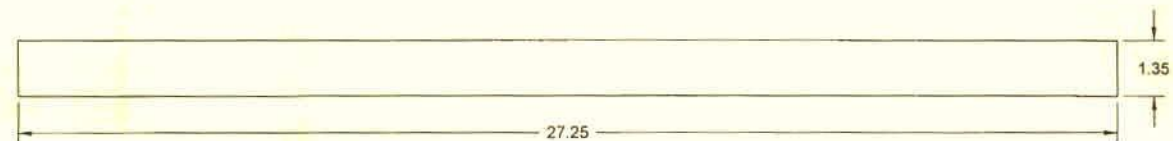


SECTION B-B
SCALE 2X



D3709-3 ANGLE
(MAKE FROM D3709-3F)

GRAIN
DIRECTION



D3709-3F ANGLE FLAT PATTERN

RELEASED
01/04/09

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV A
MFG. APPR.		D3709	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ANGLE	NTS
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